

Date: Monday, 3/17/2008 11:57:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD X-TUBE
Job Number : 38038	
Estimate Number : 10006	
P.O. Number :	Part Number : D2889
This Issue : 3/17/2008 S.O. No. :	Drawing Number : D2889 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : B
Previous Run : 38037	Material :
Written By : <u> </u>	Due Date : 4/4/2008 Qty: 1 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:A New Issue 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube material

Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	B23963

DP 8-4-4

2.0	BENDING	BENDING MACHINE
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Comment: LANDING GEAR RESOURCE 1
 1-Bend D2889 as per Dwg D2889 and Folio FT001

DP 8-4-4

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

N/A

1-Deburr and Polish

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

08-04-04 ①

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and alodine as per QSI 005 4.1
 Inside and outside of tube

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:57:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38038

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



08-04-04



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/O 37943

(-105)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08-04-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

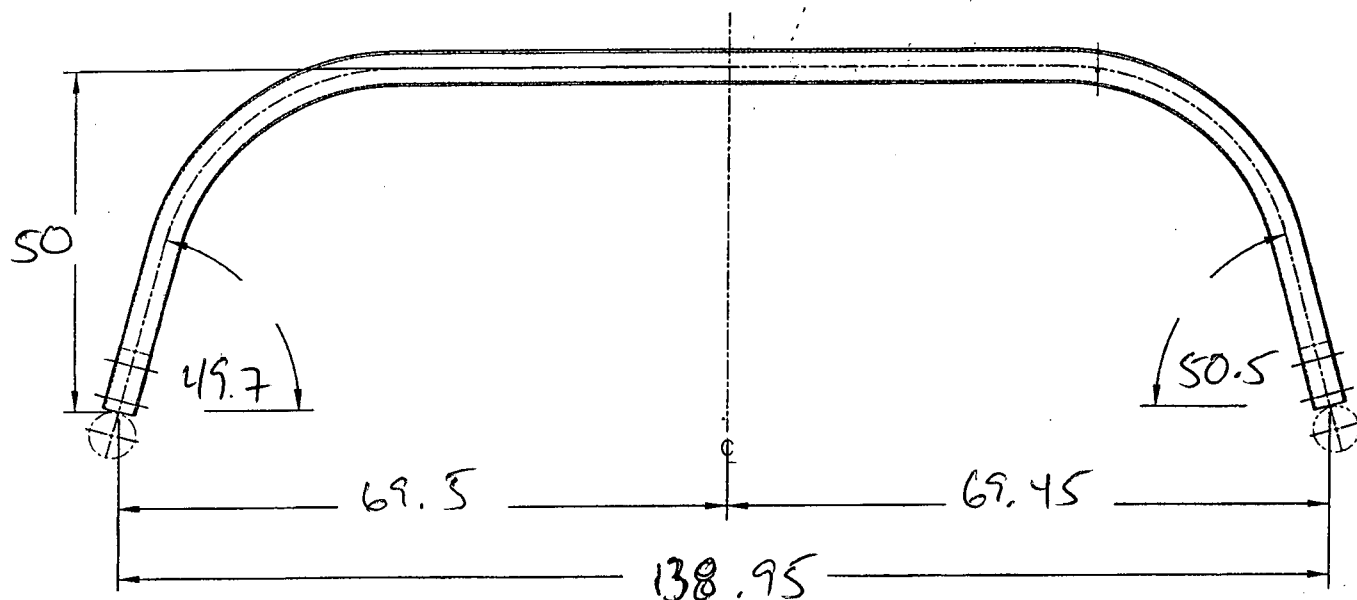
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38038
Description: Crosstube Fwd		Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1	

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



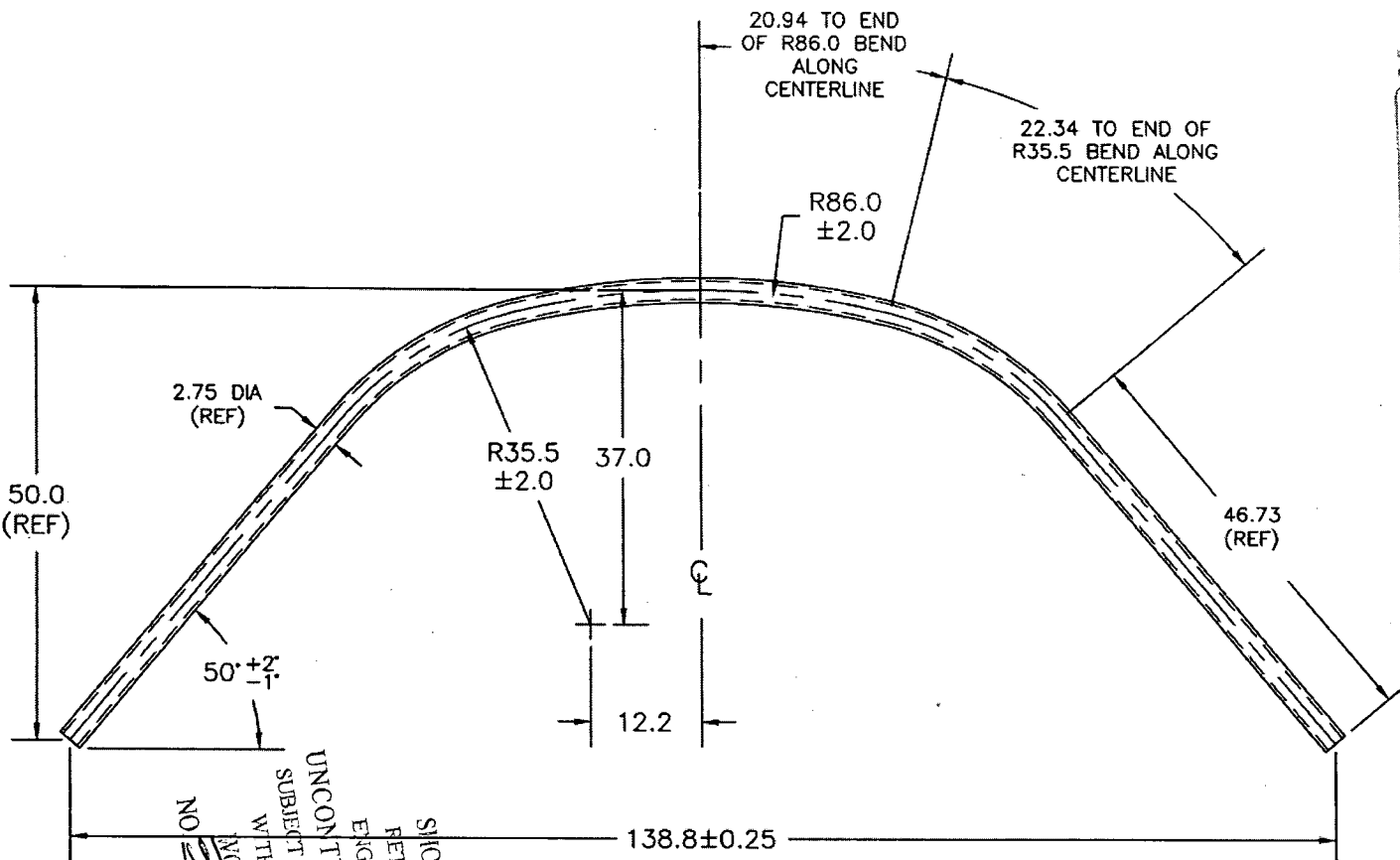
Comments

QC15 Inspection	<i>[Signature]</i>
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART**RELEASED**
02.10.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		DATE		TITLE	
02.10.18		99.05.21		FWD CROSSTUBE	
A		02.10.18		NEW ISSUE	
B		ADD TANGENT LENGTHS; CHANGE NOTES		REV. B	
				SHEET 1 OF 1	
				SCALE	
				1:20	

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ($\phi 2.75$ OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.